

Page 1

Wednesday, January 14, 2015 1:31:10 PM

Reference:

Run	Start	*NR1*
	Stop	*NR2*

Draw Nbr	Revision Nbr
IIN-D206-559	rev L

100	Document Control	0.00	CHG006
100	DOCUMENT CONTROL		
DC	Memo	0.00	
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-559-013		CHG006

160	Pick Kit	0.00
160		
Packaging	Memo	0.00
Packaging		

170	QC4- 100% Inspect kits for completeness	0.00
170		
QC	Memo	0.00
Quality Control		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 128307***128307***

Page 2

Wednesday, January 14, 2015 1:31:10 PM

Item ID: D206-559-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw

Start Date: 1/14/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/14/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

180

Packaging

Packaging

Memo

0.00

Packaging Identify and pack for shipping as per PPPD206-559-013 Location: 013

5

MAR 06 2015

DAS
06
9-09

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLS 1503-09MF
15-3-16

DQA: _____ Date: _____



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Training									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

Page 1

Wednesday, January 14, 2015 1:31:14 PM

Work Order ID: 128307

128307

Parent Item: D206-559-013

D206-559-013

Parent Item Name: Bearpaw

Start Date: 1/14/2015

Required Date: 1/14/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:J04.02.17Blank size changedKJ/JLM
IPP Rev:K 07-01-02 Was K10008 JLM
IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC
IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified
By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status														
AN4-17A Bolt		Purchased		No		160	Each	151.0000	12	48 60		27 9-89															
**																											
FEB 10 2015																											
DAS 28 9-89																											
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST343</td><td>151</td><td></td></tr><tr><td>M128813</td><td>12</td><td>M128137</td></tr><tr><td>M129909</td><td>6</td><td></td></tr><tr><td>M131139</td><td>133</td><td></td></tr></table>													Location	Loc Qty	Loc Code	ST343	151		M128813	12	M128137	M129909	6		M131139	133	
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ST343	151																										
M128813	12	M128137																									
M129909	6																										
M131139	133																										
AN4-20A Bolt		Purchased		No		160	Each	207.0000	12	48 60		27 9-89															
**																											
FEB 10 2015																											
DAS 28 9-89																											
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Location	Loc Qty	Loc Code																									
GA	51	B128137																									
116419	51																										
ST343	156																										
m128429	156																										
D2182B Seal(\$Per Foot)		Manufactured		No		160	f	147.0000	2.5	10 12.5		27 9-89															
**																											
FEB 10 2015																											
DAS 28 9-89																											
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Location	Loc Qty	Loc Code																									
ST411	147																										
115189	147																										

(D2182B050) cut qty (6) at 5.00" as per dwg ***per kit***

(D2182B050) cut qty (6) at 5.00" as per dwg ***per kit***

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Equip/Tooling									
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Material									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

Wednesday, January 14, 2015 1:31:14 PM

Work Order ID: 128307

128307

Parent Item: D206-559-013

D206-559-013

Parent Item Name: Bearpaw

Start Date: 1/14/2015

Required Date: 1/14/2015

Start Qty: 4.00

Required Qty: 4.00

D2274

Manufactured No

160

Each

372.0000

12

48 60

D2274

Radius Block

**

60x B128476
DAS 27 9-89

FEB 10 2015

DAS 28 9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST012a

360

121589

287

124363

73

D2432

Manufactured No

160

Each

0.0000

2

8 10

D2432

Bearpaw 19" X 24"

**

128313

DAS 27 9-89

DAS 28 9-89

D2438

Manufactured No

160

Each

2.0000

6

4 32

FEB 10 2015

D2438

Clamp

**

DAS 27 9-89

FEB 10 2015

DAS 28 9-89

Location

Loc Qty

Loc Code

ST542

2

124377

2

B127588

30

D2529

Manufactured No

160

Each

583.0000

12

48 60

D2529

Washer

**

DAS 27 9-89

FEB 10 2015

DAS 28 9-89

Location

Loc Qty

Loc Code

ST007

583

119633

83

127909

500

60

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 3

Wednesday, January 14, 2015 1:31:14 PM

Work Order ID: 128307

128307

Parent Item: D206-559-013

D206-559-013

Parent Item Name: Bearpaw

Start Date: 1/14/2015

Required Date: 1/14/2015

Start Qty: 4.00

Required Qty: 4.00

D2732

Manufactured No

160 f

821.0000

2.5 10 12.5

**

DAS
27
9-89
FEB 10 2015

D2732

Rubber Extrusion

6x0.50

DAS
25
9-89

Location

Loc Qty

Loc Code

ST412

471

117118

471

ST639

350

117118

350

DAS
28
9-89

bs

(D2732-050) cut qty (6) at 5.00" as per dwg ***per kit***

MS21042L4

Purchased No

160 Each

3,550.000

12

**

DAS
27
9-89
FEB 10 2015

MS21042L4

Locknut

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

704

m127813

704

ST260a

2000

m130799

2000

ST305

804

426

426

m128300

8

m130922

370

DAS
28
9-89

DAS
25
9-89

60

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Picklist Print

Page 4

Wednesday, January 14, 2015 1:31:14 PM

Work Order ID: 128307

128307

Parent Item: D206-559-013

D206-559-013

Parent Item Name: Bearpaw

Start Date: 1/14/2015

Required Date: 1/14/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

160

Each

5,689,000

24

~~96~~ 120

DAS

27

9-89

FEB 10 2015

DAS

28

9-89

NAS1149D0463.J
WASHER

DAS
25
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
CA	397	
M129682	397	
GA	408	
M129390	408	
ST260a	1153	
M129390	1153	
ST269	3731	
M129390	12	
M130799	3719	

96 + 24 = 120

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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D206-559
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5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X	X						D206-559-011	Bearpaw Kit 206 A/B
		X					D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
			X				D206-559-021	Narrow Bearpaw Kit 206 A/B
				X			D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
					X		D206-559-031	Wearplate Kit
						X	D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP

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